Figure 1. Process Flow Diagram for Scheme 1

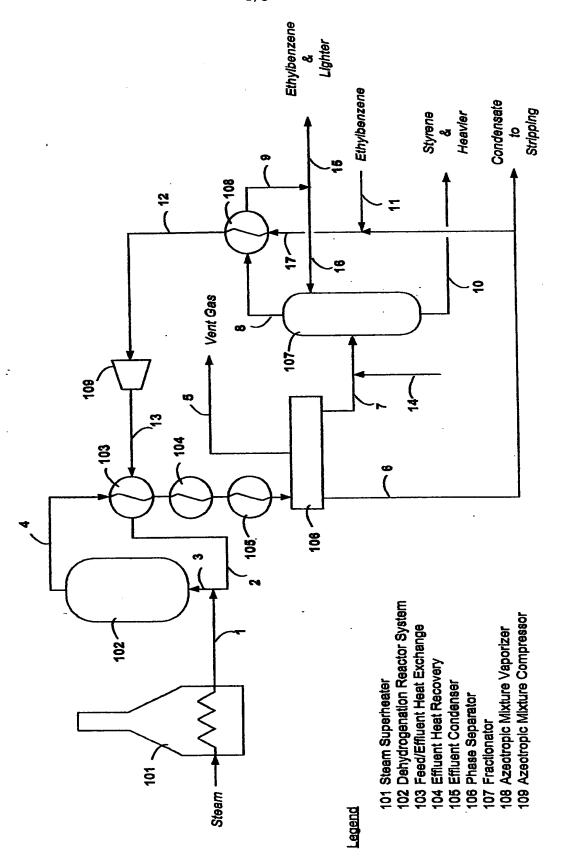
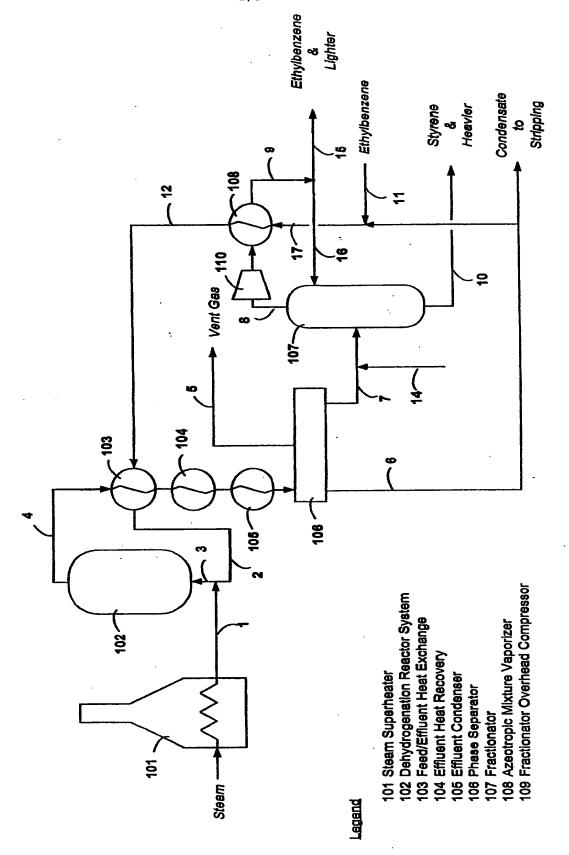


Figure 2. Process Flow Diagram for Scheme 2



3/3 Ethylbenzene & Llghter Ethylbenzene Condensate to Stripping Styrene & Heavler 4 Vent Gas _ 110 107-104 106 109 Azeotropic Mixture Compressor 110 Fractionator Overhead Compressor 101 Steam Superheater
102 Dehydrogenation Reactor System 103 Feed/Effluent Heat Exchange 108 Azeotropic Mixture Vaporizer 104 Effluent Heat Recovery 105 Effluent Condenser 106 Phase Separator 107 Fractionator 5 Steam -Legend

Figure 3. Process Flow Diagram for Scheme 3